

Work Order ID 110877

January-08-14 12:36:45 PM

110877

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Item ID: D4016-1
 Revision ID:
 Item Name: Hinge Half, Base
 Start Date: 1/13/14 Start Qty: 6.00
 Required Date: 1/13/14 Req'd Qty: 6.00
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

12-04-14

6
6

Approvals: Process Plan: MCS Date: 14-01-09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4016	A

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 1.00" LONG								

D4016 02 89 ET 14-01-14 (x12)

110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA869 AND DWG FOLIO REV: <u>AB</u> DWG REV: <u>A</u>								
	DEBURR								

D4016 02 89 ET 14-01-15 (x12)

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Item ID: D4016-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge Half, Base
 Start Date: 1/13/14 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 1/13/14 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>WAC04</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									

DAS 28 9-89 14-01-15

and 14/01/15

12 8

12x DAS 28 9-89 14-01-15

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Item ID: D4016-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Base

Start Date: 1/13/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/13/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

14-01-1614-01-16

Picklist Print

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Work Order ID: 110877

Parent Item: D4016-1

Start Date: 1/13/14

Required Date: 1/13/14

Parent Item Name: Hinge Half, Base

Start Qty: 6.00

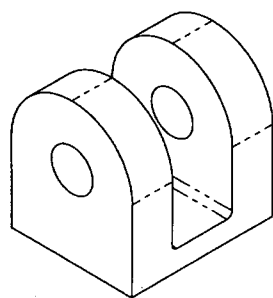
Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B as per dwg REV.A DD
10.02.22 verified by:EC

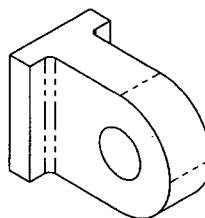
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	22.0830	0.08	0.48			
304 bar 1.00 x 1.00													
<hr/>													
<u>Location</u>						<u>Loc Qty</u>	<u>Loc Code</u>						
MAT049						22.083							
M126724						22.083							
<hr/>													

25 14-01-14

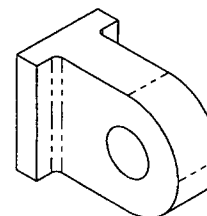
1.0



D4016-1 HINGE HALF, BASE







D4016-3 HINGE HALF, LID

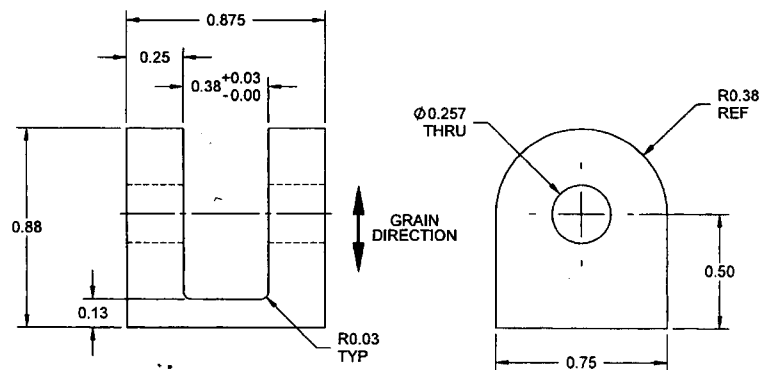


D4016-5 HINGE HALF, LIGHT LID

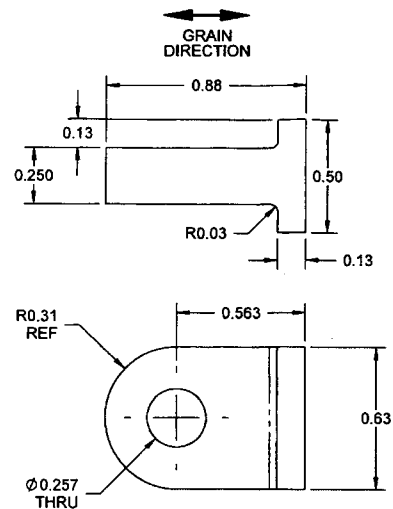
110877 MJS
14-01-09

RELEASED
2010-02-16
MD

A		NEW ISSUE		JPH	10.01.29
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
DRAWN	AJS				
CHECKED		DRAWING NO.	D4016	SHEET 1 OF 2	
MFG. APPR.		TITLE		SCALE	
APPROVED					
DE APPR.		BASKET HINGE		NTS	
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX





6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4016	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET HINGE	NTS
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